



Dart Hawkesbury
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Canada

Tel (613) 632-5200

U/R

6F9540V00231
Job Sheet 166895



DE?

Concession 4000006186 5/18/10/09

Part No: 6F9540V00231

Job Qty: 1 ea

Part Name: AW169 Lower Cutter Installation Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/19/17

Job Tracking No:

Due Date: 10/26/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Customer: Leonardo S.p.a (CAGUS03)

Piazza Monte Grappa 4 Rome, RM, 00195 Italy ph:39 0331 229294 fx:+39 0331 229730.

Ship Via:

Bill of Materials

D4842-041 manufacturer to Concession 4000006186 5/18/10/09

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		10/26/17	0.00	0.00	Packaging1	11/11/17
100	QC	1 pcs		10/26/17	0.00	0.00	QC4	5/18/17
110	DC	1 pcs		10/26/17	0.00	0.00	DC	
120	Packaging	1 pcs		10/26/17	0.00	0.00	Packaging3	DAS 21
130	QC21-FG	1 Ea		10/26/17	0.00	0.00	QC21	9-80

Part Op 110 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002
Descriptions: 120 - Identify and pack for shipping as per PPP 6F9540V00231

FEB 27 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D169-841-015 5027483	1	0	0	0

Part Specifications

Specifications could not be found.

Plex 10/19/17 2:55 PM dart.Michaud-Febrille.Victoria

D169-841-015 5027483

job 166900

DART
AEROSPACE
S027483

Dart Aerospace Ltd.

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AW169 Lower Cutter Installation Assembly

PART NO: 6F9540V00231
Revision:
Operation: QC
Change No: CHG002

Mfg Date: 12/29/17

Job No: 166895

		Supplier Concession				PAGE 1 of 2	PLANT Leonardo Helic. - Vergiate	
Supplier NC N.	AWC 006/01	Date	02.02.2017	AW Concession	400000061786	Purchase Order	4801373666	
P/N	6F9540V00231			Grade/Category	NC	Drawing Issue		
Part Description	PROTECTR, CCP ASSY LOWER			Batch Quantity	20,000	Defective Quantity	20,000	
AW NC	GUIDO BRUSCINO					A/C Type/Model	AW6	
Supplier	DART AEROSPACE LTD					Contract		
Defect FO01 - Wrong dimensions - * 02.02.2017 09:40:16 GUIDO BRUSCINO (40067) * see supplier document attached - B/N quantities and PO's listed in the Cause of Defect								
					Repetitiveness (same P/N - Defect Code)		NO ☒ YES ☐ Follow	
ENGINEERING Evaluation and Proposal								
Engineering Evaluations, including Specialist inputs: * 10.02.2017 18:01:48 MARCELLO STEFANELLI (9273) * The part is acceptable with the action proposed by the supplier applied.				Investigation Report n.		Compliance Report n.		
Classification of Deviation from Type Design i.a.w. EASA Part 21A.91 : Minore/B								
Defect effect						Limitations		
	Before Repair		After Repair					
Safety	☐ YES	☐ YES ☐ NO	☐ YES (to specificity) ☒ NO					
Life or Duration	☐ YES	☐ YES ☐ NO						
Strenght	☐ YES	☐ YES ☐ NO						
Performances	☐ YES	☐ YES ☐ NO						
Interchangeability	☐ YES	☐ YES ☐ NO						
Reliability	☐ YES	☐ YES ☐ NO						
Maintainability	☐ YES	☐ YES ☐ NO						
Installability	☒ YES	☐ YES ☒ NO						
Testability	☐ YES	☐ YES ☐ NO						
Only Appearance	☐ YES	☐ YES ☐ NO						
No Effect	☐ YES	☐ YES ☐ NO						
Repair Proposal: * 10.02.2017 18:01:48 MARCELLO STEFANELLI (9273) * See attached supplier document.					Decision ☐ Use rep. with spec.repair(not yet applied) ☒ Use repaired with known repair(yet applied) ☐ Use As Is ☐ Use repaired for tests only(see Limitations) ☐ Use As Is for tests only(see Limitations) ☐ Scrap			
Concession Classification		☐ MAJOR ☒ MINOR		Re-submit after Repair		☐ YES ☒ NO		
Mark part with Concession		☒ NO ☐ YES		Method :				
ATE	MARCELLO STEFANELLI		CPE			Date	10.02.2017	
Checks and tests to be performed								
Repair registration		with repair WO ☒		Number:				
Repair Evaluation:								
Final Decision								
S/N	Use As Is (UTI)	Use Repaired (RIL)	Scrap (SCA)	S/N	Use As Is (UTI)	Use Repaired (RIL)	Scrap (SCA)	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
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	☐	☐	☐		☐	☐	☐	
	☐	☐	☐		☐	☐	☐	
Not Serialized	Use As Is (Q.ty)	Use Repaired (Q.ty)	Scrap (Q.ty)					
Role	AW ATE	AW CPE	Inspection Clearance Repair	Quality	Customer	MoD or Authority Representative		
Signature	MARCELLO STEFANELLI							
Date	10.02.2017							

Manuf. Doc. N.	AWC 006	Date		AW Doc. N.		Purchase Order	4800671131 4800722284 4801147764 4801186922 4801218851 4801288960 4801373666
AW P/N	6F9540V00231	S/N / Batch Number	B109195 Qty. (1) B133355 Qty. (2) B134314 Qty. (1) B134315 Qty. (1) B134842 Qty. (1) B137492 Qty. (1) B137355 Qty. (2) B137816 Qty. (1) B137818 Qty. (1) B137817 Qty. (1) B140379 Qty. (3) B140381 Qty. (2) B147002 Qty. (2) B150786 Qty. (1)	Grade	A	AW Drawing Issue	B

Description	Lower Cutter Assy	Batch Q.ty	20	Defective Q.ty	20
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Manufacturer	Dart Aerospace	Model	AW169
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Defect(s) Description

Leonardo has informed Dart that there are interference issues installing the lower cable cutter D4842-041 onto the Leonardo interface bracket.

Department	Inspector	Signature	Date
Quality	DAS 16 9-89		20.7/02/01

Defect(s) Cause

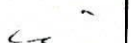
The Lower Cutter body has a dimension of 10.9 +0.25/-0.00 mm. This dimension was reported as part of the approved FAI and has been met with all delivered product.

Department	Inspector	Signature	Date
Quality	DAS 16 9-89		20.7/02/01

Corrective Action

Complete Before

In order to mitigate the interference issue for Leonardo, Dart is proposing to remove sufficient material to make the overall installation dimension at 22.15 mm +0.05/-0.35.

Department	Inspector	Signature	Date
Quality	DAS 16 9-89		20.7/02/01

For "MANUFACTURER" SUPPLIERS ONLY
ENGINEERING evaluation and proposal

Engineering evaluation

 Investigation report
 Compliance report

 n.....
 n.....

Dart's position is that this change will not impact the structural substantiation presented in Report DA169-4 for the lower cutter body since this is not a section with the lowest margin. Therefore removing 0.3 mm max from each part will not impact the structural integrity of the lower cutter assembly. The dimension on the cutter body part D4842-3/-4 will be 10.80 +0.00/-0.200.

The dimension change of the two lower cutter body parts mating, plus the sealant, anodize and primer layers will be defined as a dimension of 22.15 +0.05/-0.35 mm on the assembled lower cutterbody and will be incorporated into the D4842 drawing for inspection.

	Defect effects		Limitations
	Before any repair	After any repair	
Safety	☐ yes	☐ yes ☐ no	☐ yes (specify) ☒ no
Life	☐ yes	☐ yes ☐ no	
Strength	☐ yes	☐ yes ☐ no	
Performances	☐ yes	☐ yes ☐ no	
Interchangeability	☐ yes	☐ yes ☐ no	
Reliability	☐ yes	☐ yes ☐ no	
Maintainability	☐ yes	☐ yes ☐ no	
Installability	☒ yes	☐ yes ☒ no	
Testability	☐ yes	☐ yes ☐ no	
Only aspect	☐ yes	☐ yes ☐ no	
Repair Proposal None			Decision to use ☐ Use repaired with specific repair ☐ Use repaired with known repair ☐ Use as is ☐ Use repaired for tests (see Limitations) ☐ Use as is for tests (see Limitations) ☒ Scrap
Concession Classification		☒ Major ☐ Minor	Submit after repair
		☐ yes ☐ no	